

Date: Thursday, 4/12/2007 8:46:28 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 31736	
Estimate Number : 10462	
P.O. Number : <i>N/A</i>	Part Number : D32782
This Issue : 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31661B	Material : <i>N/A</i>
Written By : _____	Due Date : 5/10/2007 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i> 04.12.07	
Comment : Est:A 04.04.19 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.2454 f(s)/Unit Total : 14.7231 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: *M19295*

*mk 07/02/20*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

*mk 07/02/20*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

*J.F./J.L 07/04/22*

*(60)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F./J.L 07/04/22*

*(60)*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*MS*

*07/04/25*

*(60)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   H   Date: 07/04/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:46:28 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 31736

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(60X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.R

07/04/25

7.0

POWDER COATING

POWDER COATING



M103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YJ

07-04-25 (60)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FR

07/04/25

(60)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

LO

7/4/26 50

(60)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion



U J. 04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>31736</b>
<b>Description:</b> Support		<b>Part Number:</b>	<b>D3278-2</b>
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.361"	✓			
<del>.609"</del> <del>Ø.615</del>	+/-0.010	.614"	✓			
0.250	+/-0.010	.250"	✓			
1.480	+/-0.005	1.482"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.123"	✓			
2.439	+/-0.010	2.441"	✓			
1.980	+/-0.010	1.983	✓			
R0.130	+/-0.010	R.130"	✓			
Ø0.257	+0.005/-0.000	Ø.259"	✓			
R0.375	+/-0.010	R.375"	✓			
0.875	+/-0.010	.877"	✓			
0.500	+/-0.010	.500"	✓			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.725"	✓			
R0.125	+/-0.010	R.125"	✓			
0.125	+/-0.010	.129"	✓			

<b>Measured by:</b> J.F.	<b>Audited by:</b> En	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/22	<b>Date:</b> 07/04/22	<b>Date:</b>	N/A

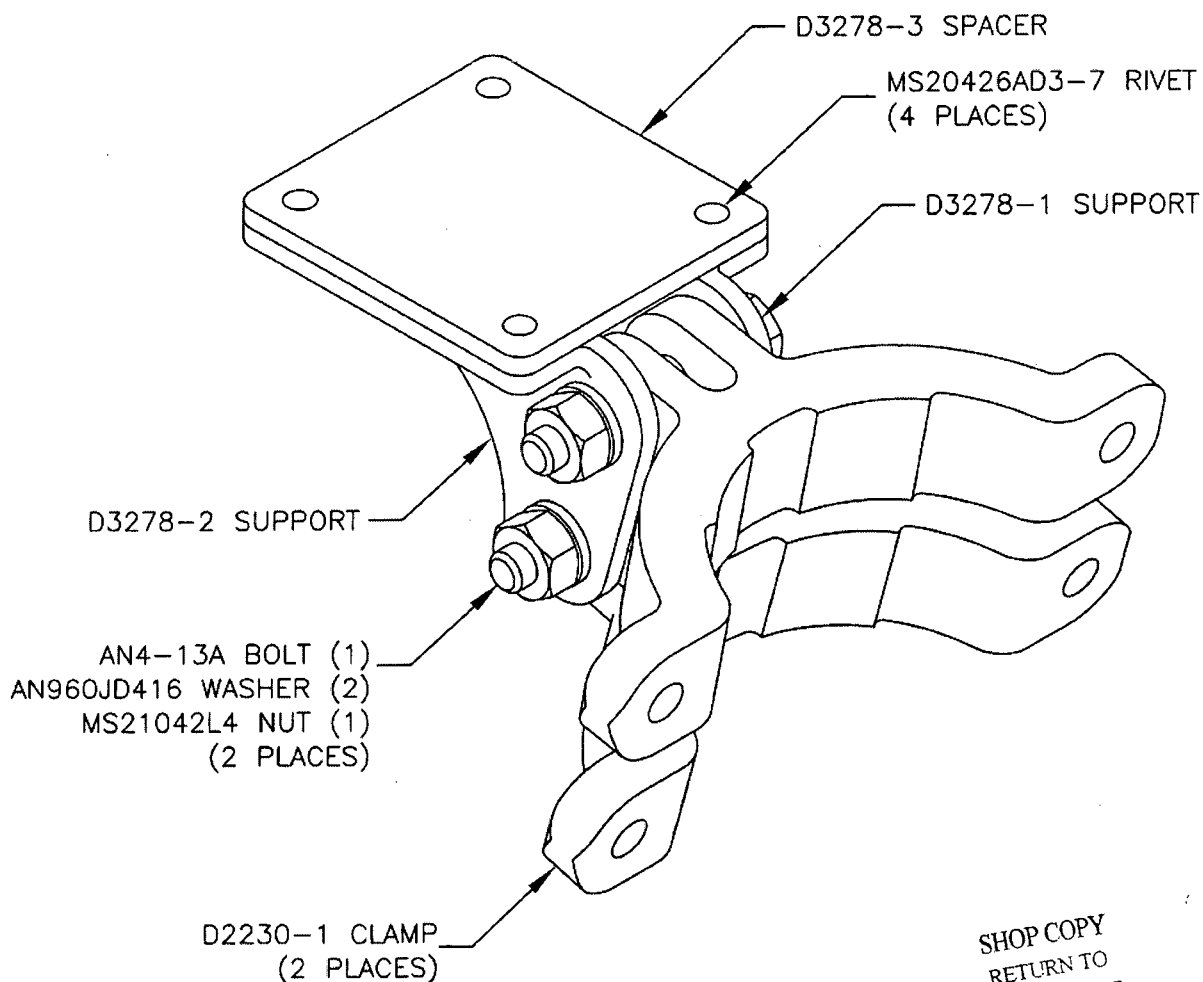
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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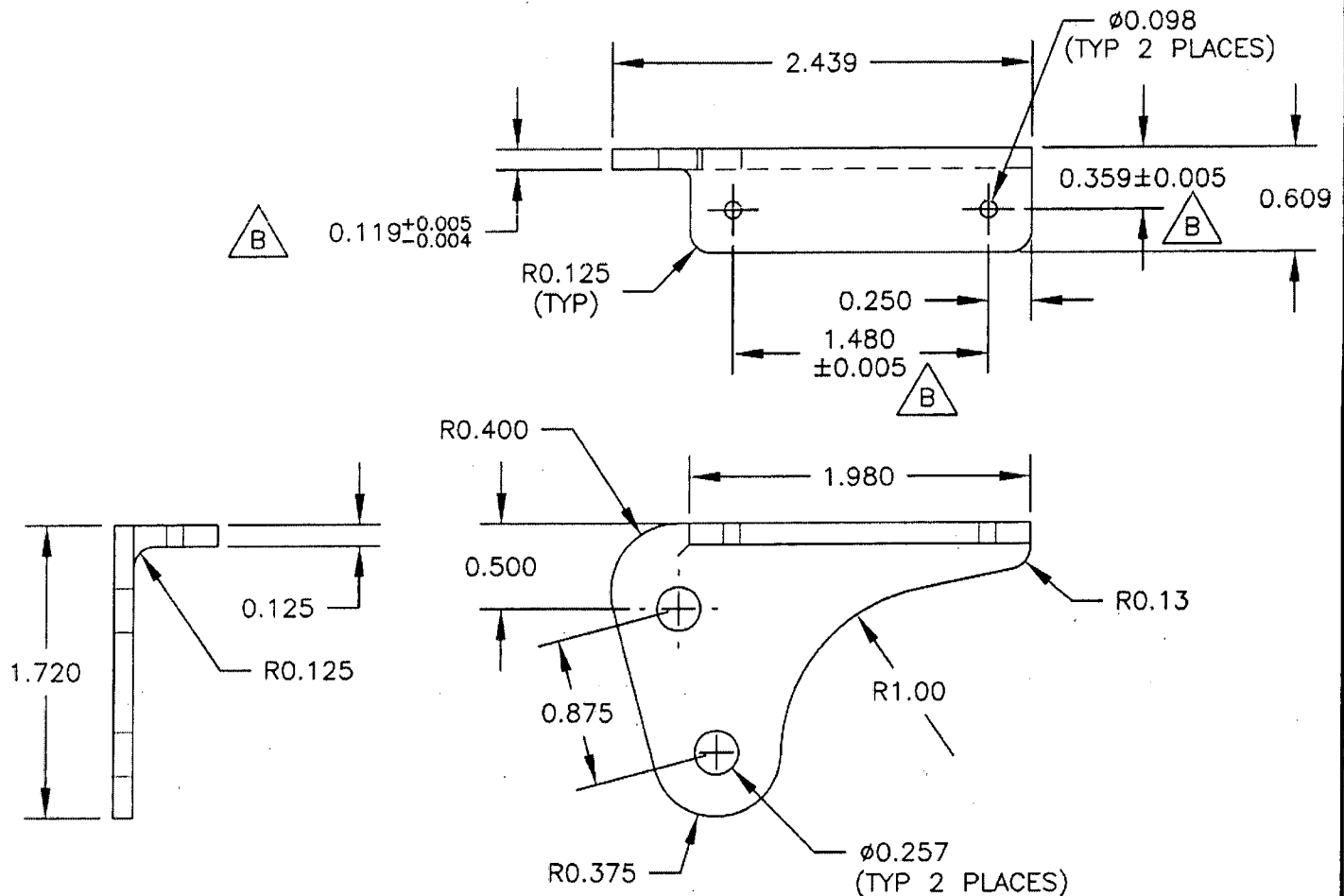
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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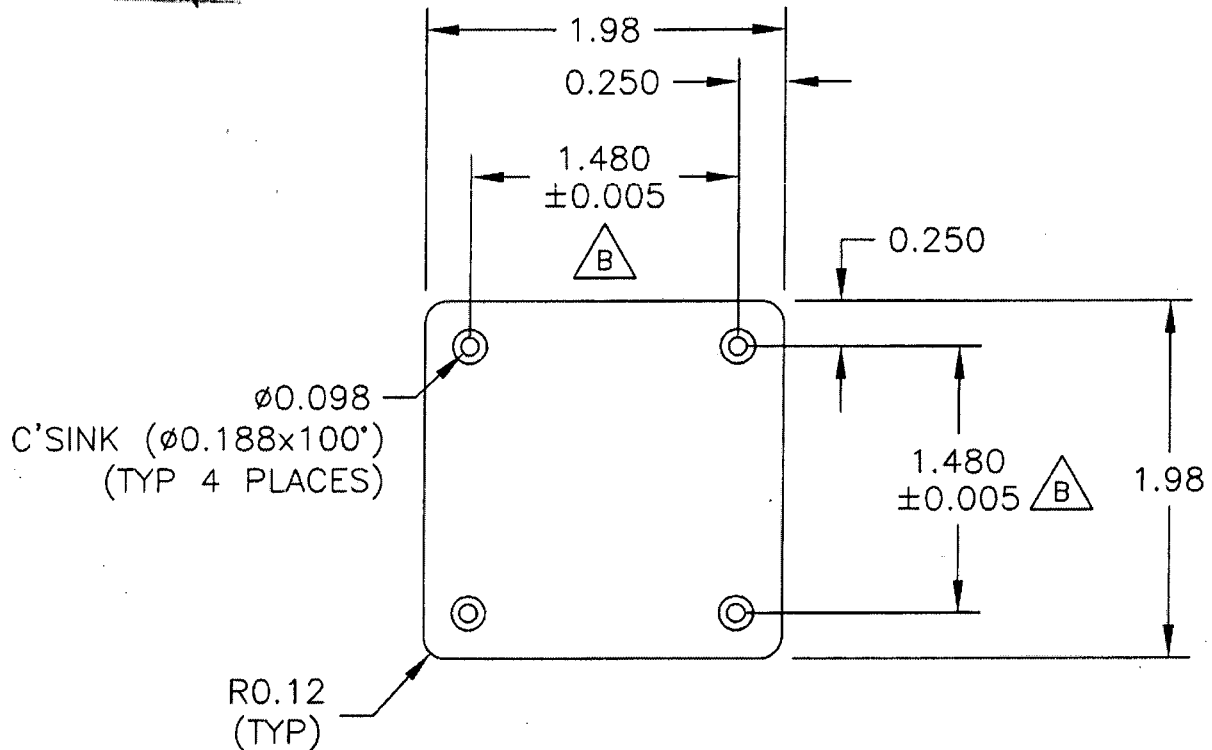
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*



**D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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